



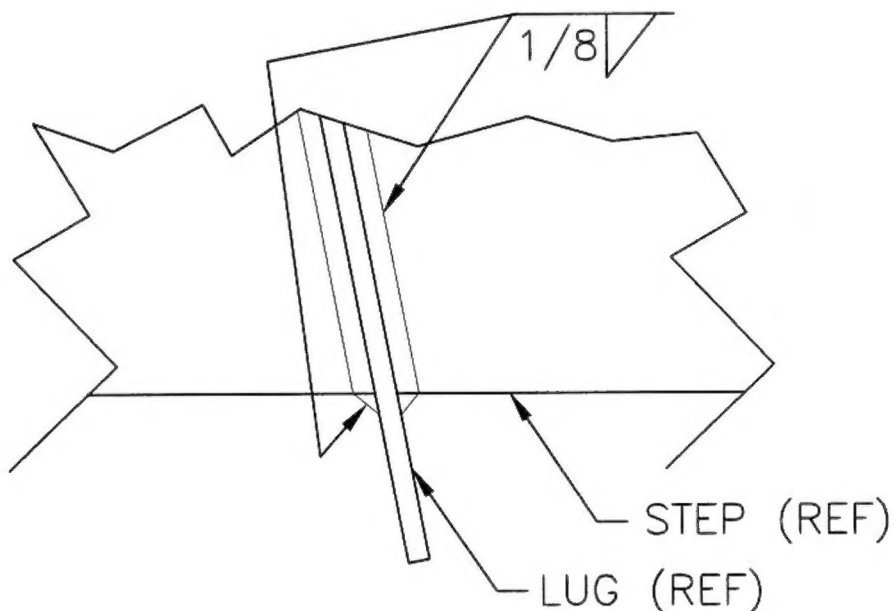
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9193	REV. A SHEET 1 OF 1
DATE 00.10.25		TITLE STEP WELD REPAIR	SCALE NTS
A	00.10.25	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND MAINTENANCE MANUAL SUPPLEMENT MMS-D206-628 REV. B
REF. CANADIAN STC: SH98-14 & FAA STC: SA00500SE

CRACKS IN THE WELDS BETWEEN THE STEP AND LUGS (AS SHOWN) CAN BE REPAIRED BY T.I.G. WELDING AS FOLLOWS:

- (1) CLEAN AREA OF PAINT, ETC...
- (2) GRIND AWAY WELD IN AREA OF CRACK.
- (3) T.I.G. WELD PER MIL-STD-2219/AMS-STD-2219 CLASS "C" USING 5356 (OR EQUIVALENT) FILLER ROD. DO NOT GRIND FLUSH.
- (4) TOUCH UP WITH ALODINE, PRIME AND PAINT PER AIRCRAFT MAINTENANCE MANUAL.



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